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the cloth being inserted between the pad and the lead cloth by lifting one end of the pad from the roll sufficiently to permit insertion of the rear portion of the cover cloth between the pad and the lead cloth for a distance of perhaps one-half of the roll circumference. The free portion of the cover cloth extends between the edges of the pad as shown more clearly in Fig. 2. The cloth is then wrapped around the pad preferably for two or more turns and will be snugly held in contact with the pad during rotation of the ironer roll in the direction indicated by the arrow. The unbeveled edge of the pad of Fig. 2 will be compressed somewhat to the contour of the beveled edge, as in Fig. 1. Beveling of both edges is not necessary, and would be more expensive with the pad-forming machines commonly used.

The beveling of one edge of the pad as shown in Fig. 2 has the advantage of giving a smoother working surface than if both edges were squared and had simple abutting engagement with each other.

Another advantage of this beveling is that the cover cloth at the point where it lies between the beveled edges slopes somewhat tangentially and so will not exert so great a thrust radially outward on the overlying portion of the pad as it would if this edge of the pad were square or in a radial plane. In the latter case, the "lift" or outward thrust would more greatly tend to raise the overlying portion of the pad somewhat away from the roll 8 and thus create a bump or raised surface that would be detrimental to the ironing operation and to diminish the life of the pad and the cover cloth.

Referring now to Figs. 4 and 5, I show a pad made in large supply and rolled for convenience of shipment and storage, the pad being unrolled and portions cut therefrom, in accordance with the length of ironer roll to be covered. The pad may be formed of the usual roves 18 knitted to a jute backing 19 and having a lead cloth 20 stitched thereto. The edges of the padding are feathered at 21 and 22 to give a beveled or scived edge effect as shown in Fig. 5, when a piece of pad has been cut from the supply roll and wrapped around the ironer roll 8. The length of the pad, from 21 to 22 may be sufficient for two or more turns around an ironer roll, or only one turn. In this case, a cover cloth may or may not be used, as desired. A cover cloth however is here indicated by the numeral 23 and will be placed in position between the outermost layer of the pad and the preceding layer. The free end of the lead cloth of Fig. 4 will be cemented or otherwise fastened to the ironer roll at 22. It will thus be seen that the user can buy a rolled supply of padding and readily cut lengths therefrom to suit ironer roll length, and that he needs only place a cover cloth around the pad after it is wrapped on a roll.

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In Fig. 4, there is a different orientation of the lead cloth 20 with respect to the pad 18 than in Fig. 2. In this instance, the lead cloth for the most part initially extends from the stitching 24 by which it is secured to the pad, along the rear face of the pad instead of only in the opposite direction as shown toward the left of the stitching 15 in Fig. 2. In applying the pads 18 to a roll, the free end of the lead cloth will be cemented to the roll at 25, and the cloth and pad will be wrapped around the roll in a counterclockwise direction from 25, as viewed in Fig. 4, the cloth 20 being given one turn and the pad one or more turns, depending upon its length circumferentially of the roll. That is, the lead cloth and pad will be given approximately a full turn counterclockwise around the roll as in Fig. 5, and the pad can either terminate at the end of one turn as in Figs. 1 and 2, or may be of much greater length than the cloth 20 and therefore be given a plurality of further turns, in a clockwise direction, as shown in Fig. 5. In either case, the beveled area at 21 will be placed in generally opposed relation to the beveled area 22.

I claim as my invention:

The method of forming and applying pads to ironer rolls, which comprises forming a strip of padding, placing a lead cloth strip against the rear face of the padding, securing one longitudinal edge of the cloth strip to the padding strip with the remainder thereof underlying the padding, dividing the composite strip transversely, to form pads, securing the free end of each cloth strip to an ironer roll along a line parallel to the roll axis, wrapping the lead cloth and the pad around the roll simultaneously and while the lead cloth is behind the rear face of the pad, to bring the edges of the pad into proximity to each other, inserting one end of a cover cloth behind the last-wrapped portion of the pad, and wrapping the protruding portion of the cover cloth around the pad.

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